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D4273-041
Job Sheet 183394



Part No: D4273-041

Job Qty: 1 ea

Part Name: Basket Base Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/17/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4279 REV B SHEETS 1,2, D4273 REV F SHEETS 1,2,3,4,5 IPP Rev:A 10.11.16 new issue DD
verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03 AS PER DWG REV.D DD
verf:EC IPP REV:D 12.07.24 AS PER DWG REV.E DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/5/18	0.00	0.00	Start Up Large Fab-6		Dr 2018-09-19
100	Large Fab	1 pcs		10/5/18	0.00	20.83	Large Fab 1		2018-09-26
110	QC	1 pcs		10/5/18	0.00	0.00	QC9		
120	QC	1 pcs		10/5/18	0.00	0.00	QC5		
125	HandFinish	1 pcs		10/5/18	0.00	0.35	HandFinish2		DR 2018-10-02
130	Powdercoat	1 pcs		10/5/18	0.00	0.66	Powdercoat2		2018-10-2
140	QC	1 pcs		10/5/18	0.00	0.00	QC3		2018-10-3
150	Packaging	1 pcs		10/5/18	0.00	0.00	Packaging3-2		2018-10-3
160	QC21-SA	1 Ea		10/5/18	0.00	0.00	QC21		21 OCT 09 2018

Part Op 100 - 1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION E-E ON PAGE 2 DWG D4273, NEED Descriptions: TO WELDED AFTHER MESH IS INSTALL) weld as per dwg D4273 using DT10317 ***visual inspect before welding mesh*** 2- Cut D4279-1 base mesh (MADE ON THIS W/O) and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends (D4279-5/-9)

130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat

M 83983 START: 2:20 OUT: 3:55 FINISH: 2:35

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5097502
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5096632
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5093386
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5096630
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5104485
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5109952
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5110912
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5099924
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5089804
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5106776
D4277-19	Rib	1 Ea (1 ea)	90-Start up Operation	5078944
D4277-3	Rib	1 Ea (1 ea)	90-Start up Operation	5110971
D4277-5	Rib	2 Ea (2 ea)	90-Start up Operation	5078915
D4277-9	Rib	1 Ea (1 ea)	90-Start up Operation	5110979
D4278-045	Rib Assembly, Fwd Cham	2 Ea (2 ea)	90-Start up Operation	5090523

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

D4278-047	Upper Rib Assembly-Straight	1 Ea (1 ea)	90-Start up Operation
D4279-5	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation
D4279-7	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4279-9	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation
D4306-043	Rib Assembly, LH	1 Ea (1 ea)	90-Start up Operation
D4306-045	Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4306-1	Rib	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation

5078860
 50575288
 5083619
 5083812
 5017134
 5061084
 5061190
 5089950
 5093684

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	92	0
	D3913-1	1	7	0
	D3913-15	1	22	0
	D3913-3	1	8	0
	D3913-9	1	12	0
	D3916-5	3	30	0
	D4016-1	3	10	0
	D4017-7	3	58	0
	D4021-1	3	55	0
	D4034-041	1	9	0
	D4277-19	1	2	0
	D4277-3	1	0	0
	D4277-5	2	6	0
	D4277-9	1	0	0
	D4278-045	2	4	0
	D4278-047	1	4	0
	D4279-5	1	4	0
	D4279-7	2	11	0
	D4279-9	1	10	0
	D4306-043	1	3	0
	D4306-045	1	4	0
	D4306-1	1	6	0
	D4672-1	2	24	0
	M304EX0.75-16F	32	2,172	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Suspected Unapproved		Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Rework ☐ Set-up ☐ Iron tube ☐ Scrap ☐ Machining ☐ Small fab ☐ Use-as-is ☐ Thermoplastic ☐ Insulating ☐ Approved ☐ Large fab ☐ Large dig ☐	
Date : _____		Step #: _____			
Description Work Order Deviation					
DART Aerospace Ltd. 1270 Aberdeen Street Haverhill, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com					
Approval					

Root Cause			FAULT CATEGORY		
Environment	☐	No Re-verification	☐	Pressure/Forced	☐
Design	☐	Operator	☐	Bending	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐
Material	☐	Use for Testing	☐	Cuffs	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐
Past Expiry Date	☐	Manufacturing Process	☐	Temperature/Cure	☐
Misidentified	☐	Past Due	☐	Set-up	☐
			☐	BOM/Route	☐
			☐	Broken/Damage/Defect	☐
			☐	Inspection Incomplete/Unqualified	☐
			☐	Contamination	☐
			☐	Countersink	☐
			☐	Cut Too Short	☐
			☐	Instructions Incomplete/Unclear	☐
			☐	Drill Holes	☐
			☐	Power Loss/Surge	☐
			☐	Folio/Program	☐
			☐	Grain	☐
			☐	Weld	☐
			☐	Wrong Stock Pulled	☐
			☐	Out of Sequence	☐
			☐	Off-set	☐
			☐	Mislabeled	☐
			☐	Fit/Function	☐
			☐	Misaligned/off center	☐
			☐	Positioned Wrong	☐
			☐	Outside Dimensions	☐
			☐	Over/Under tolerance	☐
			☐	Part Incorrect	☐
			☐	Part Lost/Missing	☐
			☐	Part Moved	☐
			☐	Drawing	☐
			☐	Finish	☐
			☐	Misread	☐
			☐	Turning Sequence	☐
			☐	OTHER :	